

Date: Wednesday, 4/26/2006 7:13:27 AM
 User: Linda Lacelle

Process Sheet

| | | | | | |
|-----------------------|--|--|------------------|------------------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : BASKET BASE ASSEMBLY (350) | |
| Job Number | : 26844A | | Part Number | : D2221 | |
| Estimate Number | : 10189 | | Drawing Number | : D2221/D2235 | |
| P.O. Number | : N/A | | Project Number | : N/A | |
| This Issue | : 4/26/2006 S.O. No. : N/A | | Drawing Revision | : F/B1 | |
| Prsht Rev. | : NC | | Material | : N/A | |
| First Issue | : N/A | | Due Date | : 5/3/2006 | |
| Previous Run | : 26721C | | Qty: | 1 Um: Each | |
| Written By | : <u>See COMMENT below</u> | | | | |
| Checked & Approved By | : <u>See ABOVE USER & DATE</u> | | | | |
| Comment | : Est Rev:J 05.09.02 Added D3442-1KJ/JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|--------------------------------|
| 1.0 | D31661 | Basket Hoop | |
| | | | |
| | | Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) | |
| | | Pick: | |
| | Qty Part Number | Description | Batch |
| | 4 D3166-1 | RIB | <u>B26717</u> CPL 06-05-01 |
| 2.0 | D22323 | Basket Hinge | |
| | | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) | |
| | | Pick: | |
| | Qty Part Number | Description | Batch |
| | 2 D2232-3 | Hinge bracket | <u>B25239</u> CPL 06-04-27 |
| 3.0 | D2325 | Support Gusset (350 Bask) | |
| | | | |
| | | Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) | |
| | | Pick: | |
| | Qty Part Number | Description | Batch |
| | 4 D2325 | Support Gusset | <u>B25687</u> → 1 CPL 06-04-27 |
| 4.0 | D23273 | Spacer Bushing | |
| | | | |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) | |
| | | Pick: | |
| | Qty Part Number | Description | Batch |
| | 2 D2327-3 | Bushing | <u>B25823</u> CPL 06-04-27 |

Date: Wednesday, 4/26/2006 7:13:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 26844A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B26204 CPL 06.04.27

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim 326739 CPL 06.05.05

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal M100722 CPL 06.05.02

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M100748 336.01 CPL 06.05.01

9.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

CPL 06.05.10

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

Date: Wednesday, 4/26/2006 7:13:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 26844A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-05-00

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-05-10

①

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



J 06-05-10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M160901

Expiry date: 11/2006

SAD 06-05-16

①

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

①
P 06/05/18

Job Completion



U 06-05-18

